

Date: Tuesday, 21/11/2006 1:40:50 PM
User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : LITTER DECKPLATE 350
Job Number : 29143	
Estimate Number : 10357	
P.O. Number : <i>N/A</i>	Part Number : D2344
This Issue : 21/11/2006 S.O. No. : <i>N/A</i>	Drawing Number : D2344 REV.E
Prsht Rev. : NC	Project Number : N/A
First Issue : <i>N/A</i> Type : MACHINED PARTS	Drawing Revision : E
Previous Run : 29143	Material : <i>N/A</i>
Written By : <i>[Signature]</i>	Due Date : 28/11/2006 Qty: 4 Um: Each
Checked & Approved By : <i>[Signature]</i>	
Comment : Est Rev:D 00.06.26 Removed P/O for powder coat EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M2024T3S063	2024-T3 .063 sheet
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Comment: Qty.: 0.7823 sf(s)/Unit Total : 3.1290 sf(s)

Material: 2024-T3 QQ-A-250/5) .063

Batch *M101022 ml 06 11 230*

(4)

2.0	WATER JET	FLOW WATER JET
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Prog Rev: E
Dwg Rev: E

(4)

Comment: FLOW WATER JET *ml 06 11 30*

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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ml 06 11 30

(4)

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

11/06/11/30 (4)

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL/MED FAB

1-Deburr sharp edges *SAD 06:12:02*

(4)

2-Countersink holes per Dwg D2344

ml 06/12/12

(4)

Date: Tuesday, 21/11/2006 1:40:50 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LITTER DECKPLATE 350

Job Number: 29143

Part Number: D2344

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Feb 12.12 (4)

Comment: INSPECT WORK TO CURRENT STEP

7.0

POWDER COATING

POWDER COATING



M100700

(4)

Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

m. R/ a n

07/01/03

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

R 7/1/4

(4)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: Identify and Stock

Location: *57171*

R 7/01/4

(4)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07.01.05

07-01-05

Job Completion



7.0

Acid: Alocine as per QSI 005 4.1

JN 08-12-20

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
06.12.12	7.0	Add Alocen Pr QSI 005 4.1					
	7.1	<i>permanent change</i>	<i>EE</i>	06.12.12			<i>06.12.12</i>

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: *ED* Date: *07/01/08*
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 10/24/2006 11:06:29 AM
 User: Kim Johnston

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	LITTER DECKPLATE 350
Job Number :	29143		
Estimate Number :	10357		
P.O. Number :		Part Number :	D2344
This Issue :	10/24/2006	Drawing Number :	D2344 REV.E
Prsht Rev. :	NC	Project Number :	N/A
First Issue :	/ /	Drawing Revision :	E
Previous Run :	25294	Material :	
Written By :		Due Date :	11/6/2006
Checked & Approved By :	<i>[Signature]</i>	Qty:	4
Comment :	Est Rev:D 00.06.26 Removed P/O for powder coat EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M2024T3S063	2024-T3 .063 sheet
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Comment: Qty.: 0.7823 sf(s)/Unit Total : 3.1290 sf(s)

Material: 2024-T3 QQ-A-250(5) .063

Batch _____

water

2.0	SHEAR	SHEAR
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Comment: Shear blanks: 17.100" X 6.380" +0.015/-0.000

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: Haas #1

Machine per folio D2344 & dwg D2344

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

5.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

6.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
-----	-------------	-------------------------------



Comment: SMALL/MED FAB

1-Deburr sharp edges

2-Countersink holes per Dwg D2344

DART AEROSPACE LTD		Work Order:	29143
Description: Litter Deck Plate Kit (350)		Part Number:	D2344
Inspection Dwg: D2344 Rev: E		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

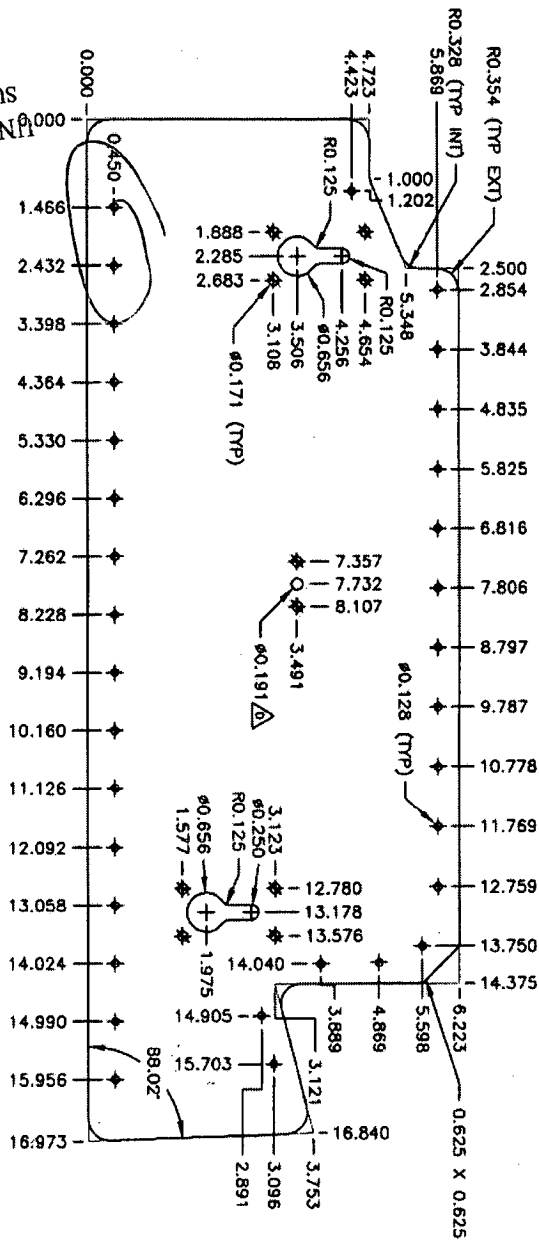
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.991	+/-0.005	0.990	✓		vern	
6.223	+/-0.010	6.221	✓		vern	
5.598	+/-0.010	5.598	✓		vern	
4.869	+/-0.010	4.869	✓		vern	
3.889	+/-0.010	3.890	✓		vern	
3.096	+/-0.010	3.097	✓		vern	
2.891	+/-0.010	2.895	✓		vern	
16.973	+/-0.010	16.973	✓		Measuring tape	
0.966	+/-0.005	0.965	✓		vern	
0.450	+/-0.010	0.453	✓		vern	
4.423	+/-0.010	4.425	✓		vern	
4.723	+/-0.010	4.726	✓		vern	
1.202	+/-0.010	1.196	✓		vern	
5.869	+/-0.010	5.869	✓		vern	
4.654	+/-0.010	4.655	✓		vern	
Ø0.656	+0.005/-0.000	0.656	✓		vern	
1.888	+/-0.010	1.887	✓		vern	
2.285	+/-0.010	2.289	✓		vern	
2.683	+/-0.010	2.688	✓		vern	
Ø0.171	+0.005/-0.000	0.171	✓		vern	
0.750	+/-0.005	0.753	✓		vern	
3.491	+/-0.010	3.495	✓		vern	
Ø0.191	+0.005/-0.000	0.191	✓		vern	
0.796	+/-0.005	0.795	✓		vern	
3.123	+/-0.010	3.127	✓		vern	
1.587	+/-0.010	1.580	✓		vern	
1.975	+/-0.010	1.977	✓		vern	

Measured by: <i>MM</i>	Audited by: <i>DA</i>	Prototype Approval:	N/A
Date: 06/11/30	Date: 06/11/30	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.06.25	New Issue P/O D350-616-015	KJ/JLM	<i>[Signature]</i>

MATERIAL: 2024-T3 (QQ-A-250/5) 0.063-0.071 THICK
FINISH: POWDER COAT BLACK CRINKLE (4.3.5.3) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

NO. 29173
WORK ORDER
WITHOUT NOTICE
SUBJECT TO AMENDMENT
UNCONTROLLED COPY
ENGINEERING
RETURN TO
SHOP COPY
MATERIAL



DESIGN KE		DRAWN BY KE		DRAWING NO. D2344	TITLE SCALE	DATE 98.06.19	A	95.01.14	NEW ISSUE
CHECKED KE		APPROVED KE					B	95.02.09	MOVED KEY HOLES
							D	95.03.06	0.191 WAS 0.197
							E	98.06.19	0.063-0.071 THICK WAS 0.071 (TSR A371)

RELEASED 18/06/22

**DART**